

In the Claims

1. (Currently amended): A process for reforming a planar pre-finished medium density fiber (MDF) board ~~having at least one pre-finished surface which carries at least one coating~~, said process comprising the steps of:
 - applying at least one pigment layer over the medium density fiber board,
 - applying at least one protective top layer over the at least one pigment layer to pre-finish at least one surface of the medium density fiber board,
 - placing a the planar pre-finished medium density fiber board in a heated press mold;
 - closing the heated press mold while the pre-finished medium density fiber board is located therein;
 - applying pressure and heat to the pre-finished medium density fiber board using said heated press mold so that said at least one pre-finished surface is reformed without cracking bubbling, or removal of said at least one coating;
 - opening the heated press mold; and
 - removing the pre-finished medium density fiber board from the heated press mold.

2. (Original): The process of claim 1, wherein said heated press mold has at least one relief surface and wherein said step of applying pressure and heat is performed so that said at least one relief surface reforms at least a portion of said at least one pre-finished surface of the pre-finished medium density fiber board.

3. (Original): The process of claim 2, wherein said at least one relief surface is configured and said step of applying pressure and heat is performed so that said at least one pre-finished surface is reformed to a depth of no more than 0.045 inch in depth.
4. (Canceled).
5. (Currently amended): The process of claim ~~4~~ 1, further comprising the application of ~~wherein said at least one pigment layer and said at least one protective top layer are applied over~~ at least one ground layer which serves as a primer.
6. (Currently amended): The process of claim ~~4~~ 1 wherein said at least one protective top layer includes a release agent which prevents said at least one protective top layer from adhering to the heated press mold during said step of applying heat and pressure.
7. (Original): The process of claim 1, further comprising the step of remoisturizing said pre-finished medium density fiber board after said step of applying pressure and heat to a predetermined moisture content.
8. (Original): The process of claim 1, wherein said heated press mold is heated to a temperature sufficient to soften resin in said at least one coating so that fibers and said resin tend to flow rather than break during reforming of said at least one pre-finished surface, and wherein said temperature is sufficiently low to prevent sticking of said at least one coating to the heated press mold.

9. (Original): The process of claim 8, wherein said heated press mold is heated to about 400°F and said pressure is about 1100 pounds per square inch during said step of applying pressure and heat.

10. (Currently amended): The process of claim 1, wherein said at least one pre-finished surface is provided using a pre-finishing method comprising the steps of:
applying a ground layer to at least one major surface of a raw medium density fiber board prior to applying the at least one pigmented layer and the at least one protective top layer;
said at least one protective top layer having a polymer composition, such that said at least one protective top layer is at least one polymer top layer,
~~applying at least one pigment layer over said ground layer; and~~
~~applying at least one polymer top layer over said at least one pigment layer,~~
said at least one polymer top layer having a release agent which prevents said at least one polymer top layer from adhering to said heated press mold during said step of applying pressure and heat.

11. (Original): The process of claim 10, wherein: said raw medium density fiber board is about 0.125 inch thick;
said ground layer is applied to the raw medium density fiber board with a thickness of about 1 mil;
said at least one pigment layer comprises two pigment layers, each of the two pigment layers having a thickness of about 1 mil; and said at least one polymer top layer

comprises two polymer top layers, each of the two 8 polymer top layers having a thickness of about 0.5 mil.

12. (Currently amended): The process of claim 1, wherein ~~said at least one pre-finished surface is provided using a pre-finishing method comprising the steps of:~~
~~applying at least one pigment layer to at least one major surface of a raw medium density fiber board; and~~
~~applying at least one polymer top layer over said at least one pigment layer;~~
said at least one protective top layer has a polymer composition, such that said at least one protective top layer is at least one polymer top layer,
said at least one polymer top layer having a release agent which prevents said at least one polymer top layer from adhering to said heated press mold during said step of applying pressure and heat.

13. (Original): The process of claim 12, wherein:
said raw medium density fiber board is about 0.125 inch thick;
said at least one pigment layer comprises three pigment layers, each of the three pigment layers having a thickness of about 0.3 mil; and
said at least one polymer top layer has a thickness of about 0.15 to 0.2 mil.

14. (Original): The process of claim 1, wherein:
said pre-finished medium density fiber board is a flat, pre-finished door skin; said heated press mold has at least one relief surface; and

said step of applying pressure and heat is performed so that said at least one relief surface reforms said at least one pre-finished surface with at least one ornamental feature.

15. (Original): The process of claim 14, wherein said at least one relief surface is configured so that said at least one ornamental feature includes simulated door panels.

16. (Original): The process of claim 14, wherein said at least one relief surface is configured so that said at least one ornamental feature includes a simulated wood grain texture.

17. (Original): The process of claim 15, wherein said at least one relief surface is configured so that said at least one ornamental feature includes both a simulated wood grain texture and simulated door panels, and wherein said simulated wood grain texture is reformed to a shallower depth than said simulated door panels.

18. (Original): The process of claim 14, wherein said at least one relief surface is configured and said step of applying pressure and heat is performed so that reforming of said at least one pre-finished surface is no greater than 0.045 inch in depth.

19. (Original): The process of claim 14, further comprising the step of remoisturizing said pre-finished medium density fiber board after said step of applying pressure and heat, to replace moisture lost by said pre-finished medium density fiber board during said step of applying pressure and heat.

20. (Original): The process of claim 14, wherein said heated press mold is heated to a temperature sufficient to soften resin in said at least one coating so that fibers and said resin tend to flow rather than break during reforming of said at least one pre-finished surface, and wherein said temperature is sufficiently low to avoid sticking of said at least one coating to the heated press mold.

21. (Original): The process of claim 14, wherein said heated press mold is heated to about 400°F and said pressure is about 1100 pounds per square inch during said step of applying pressure and heat.

22. (Currently amended): The process of claim 14, wherein said at least one pre-finished surface is provided using a pre-finishing method comprising the steps of:
applying a ground layer to at least one major surface of a flat, raw medium density fiber board prior to applying the at least one pigmented layer and the at least one protective top layer;
said at least one protective top layer having a polymer composition, such that said at least one protective top layer is at least one polymer top layer,
~~applying at least one pigment layer over said ground layer; and~~
~~applying at least one polymer top layer over said at least one pigment layer,~~
said at least one polymer top layer having a release agent which prevents said at least one polymer top layer from adhering to said heated press mold during said step of applying pressure and heat.

23. (Original): The process of claim 22, wherein:

said flat, raw medium density fiber board is about 0.125 inch thick;

said ground layer is applied to the raw medium density fiber board with a thickness of about 1 mil;

said at least one pigment layer comprises two pigment layers, each of the two pigment layers having a thickness of about 1 mil; and

said at least one polymer top layer comprises two polymer top layers, each of the two polymer top layers having a thickness of about 0.5 mil.

24. (Currently amended): The process of claim 14, wherein ~~said at least one pre-finished surface is provided using a pre-finishing method comprising the steps of:~~
~~applying at least one pigment layer to at least one major surface of a flat, raw medium density fiber board; and applying at least one polymer top layer over said at least one pigment layer,~~

said at least one protective top layer having a polymer composition, such that said at least one protective top layer is at least one polymer top layer,

said at least one polymer top layer having a release agent which prevents said at least one polymer top layer from adhering to said heated press mold during said step of applying pressure and heat.

25.-37. (Canceled)

38. (Original): A process for making a pre-finished medium density fiber (MDF) board which is reformable after finishing, said process comprising the steps of:
applying at least one pigment layer to over at least one major surface of a planar raw medium density fiber board; and

applying at least one polymer top layer over said at least one pigment layer, said at least one polymer top layer having a release agent which prevents said at least one polymer top layer from adhering to said heated press mold during press molding, wherein said at least one pigment layer and said at least one polymer top layer are applied using materials and thicknesses thereof which are capable of withstanding press-molding at temperatures and pressures sufficient to reform said at least one pigment layer and said at least one polymer layer, without cracking, bubbling, and adherence to a press mold.

39. (Original): The process of claim 38, wherein:

said raw medium density fiber board is about 0.125 inch thick;

said at least one pigment layer comprises three pigment layers, each of the three pigment layers having a thickness of about 0.3 mil; and

said at least one polymer top layer has a thickness of about 0.15 to 0.2 mil.

40. (Original): The process of claim 38, wherein said at least one pigment layer and said at least one polymer top layer are applied using a rolling process.

41. (Re-instated, formerly claim 25) The process of claim 24, wherein:

said flat, raw medium density fiber board is about 0.125 inch thick;

said at least one pigment layer comprises three pigment layers, each of the three pigment layers having a thickness of about 0.3 mil; and

said at least one polymer top layer has a thickness of about 0.15 to 0.2 mil.